

Date: Tuesday, 10/30/2007 2:48:56 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FRAME WELDMENT
 Job Number : 35439
 Estimate Number : 11202
 P.O. Number : N/A Part Number : D3330041
 This Issue : 10/30/2007 S.O. No. : N/A Drawing Number : D3330 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : C
 Previous Run : 34177 Material : N/A
 Due Date : 11/15/2007 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : 07.10.31
 Comment : Est. A 05.01.13 New Issue KJ/JLM
 est B 07.05.14 revC dwg ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D33301 Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1 D3330-1 Panel

B35482 → 5 B30958 → 1

S/S 07/11/20

2.0 D33302 Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1 D3330-2 Panel

B30958 → 3 # 15Hort ✓
B35486 → 3

S/S 07/11/20

3.0 D33303 Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1 D3330-3 Panel

B35487 → 2 ✓
B30959 → 4

S/S 07/11/20

4.0 D33305 Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Rail

Pick:

Qty Part Number Description Batch

1 D3330-5 Panel

B36011 → 5 *
B30960 → 1

S/S 07/11/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:48:56 PM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 35439

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D33307

Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Panel

Pick:

Qty	Part Number	Description	Batch
1	D3330-7	Panel	B34122 → 6 ✓

Jef 07/11/20

6.0

D33309

Top Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Top Plate

Pick:

Qty	Part Number	Description	Batch
1	D3330-9	Panel	B35488 → 6 ✓

Jef 07/11/20

7.0

D333011

Long Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Long Pin Bracket

Pick:

Qty	Part Number	Description	Batch
1	D3330-11	Long Pin Bracket	B35483 → 5 ✓

Jef 07/11/20

8.0

D333013

Short Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Short Pin Bracket

Pick:

Qty	Part Number	Description	Batch
1	D3330-13	Short Pin Bracket	B23235 → 6 ✓

Jef 07/11/20

9.0

D333015

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Handle

Pick:

Qty	Part Number	Description	Batch
1	D3330-15	Handle	B34198 → 6 ✓

Jef 07/11/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:48:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 35439

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

D333017

Handle Socket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)
Handle Socket

Pick:

Qty Part Number Description Batch
1 D3330-17 Handle Socket

B35484 → 2 ✓
B30956 → 4 JHS 07/11/20

11.0

D333019

Handle Rim



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)
Handle Rim

Pick:

Qty Part Number Description Batch
1 D3330-19 Handle Rim

2 SHORT
B30957 → 6 * JHS 07/11/20

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Assemble and Weld as per Dwg Dwg D3330 using D3330-041T1
Identify as D3330-041

JHS 07/11/20

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-12-04 (6)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 7/12/04 (x6)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M/8052

BL 07-12-04

(6)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 07/12/04 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 07/12/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:48:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 35439

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5447 PC 7/12/05 (6)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 7/12/06

Job Completion



U 7-12-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

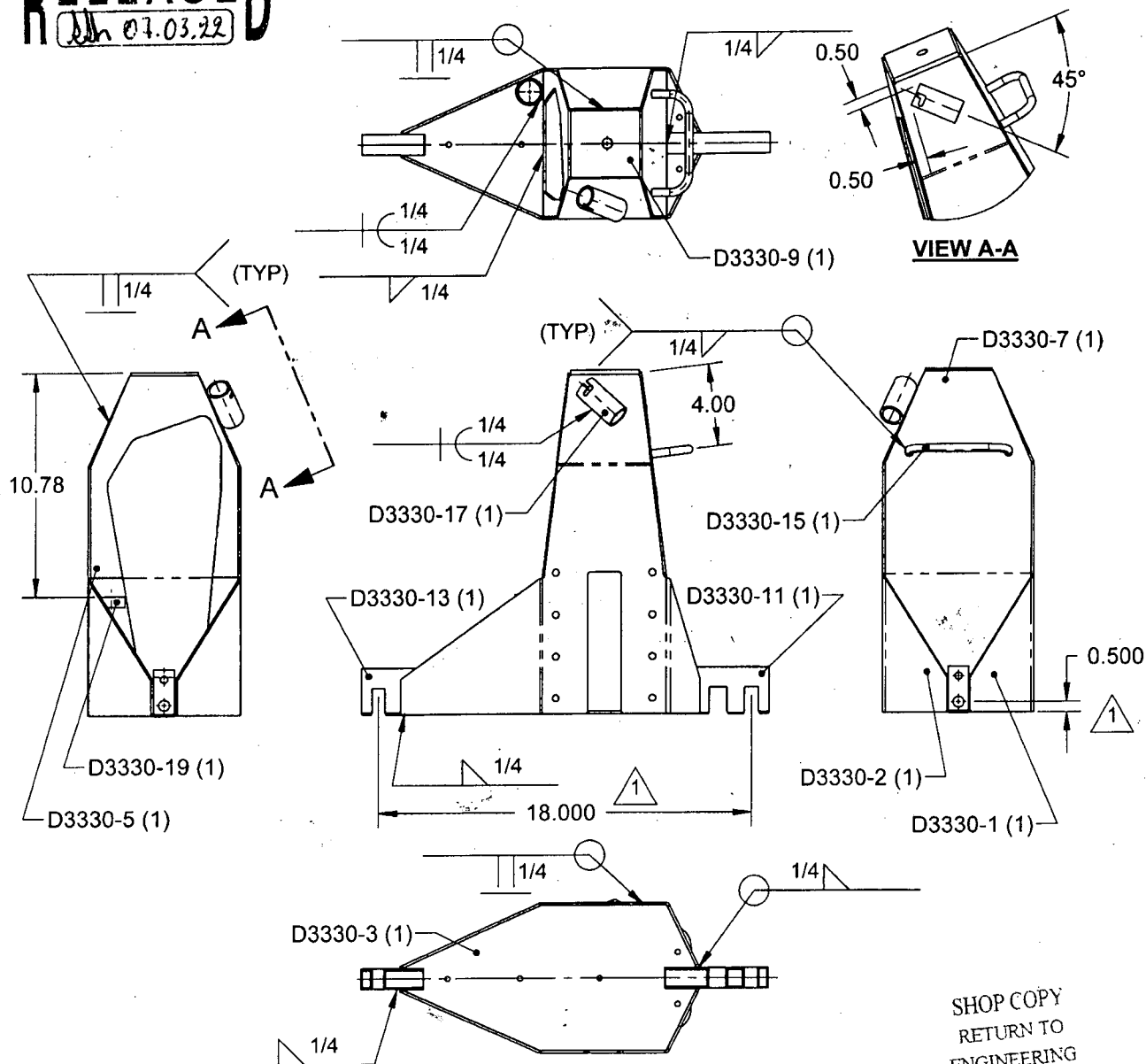
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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07.03.22

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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/-2 BY 0.125	

**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

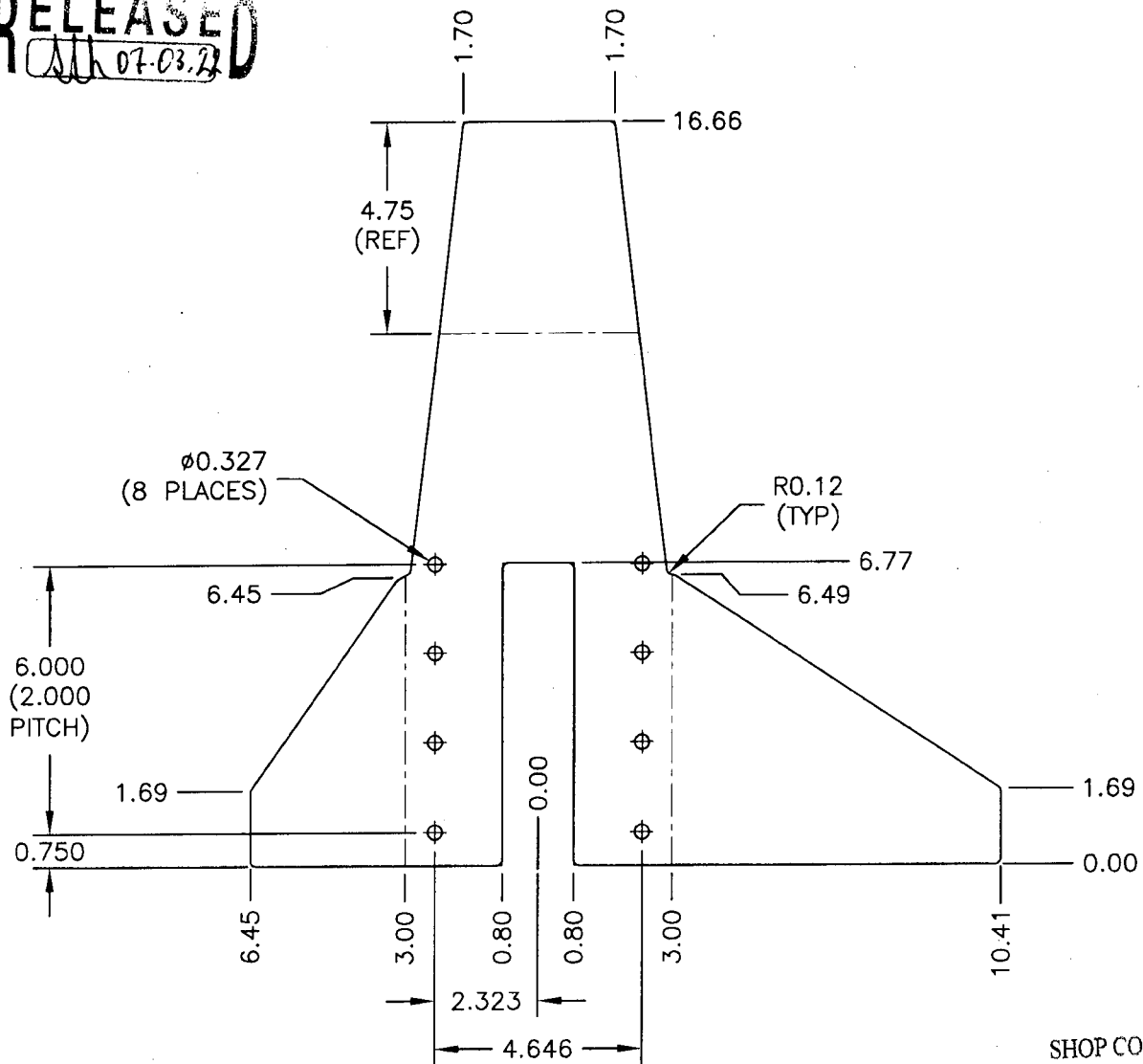
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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
[Signature] 07-03-20**D3330-1 PANEL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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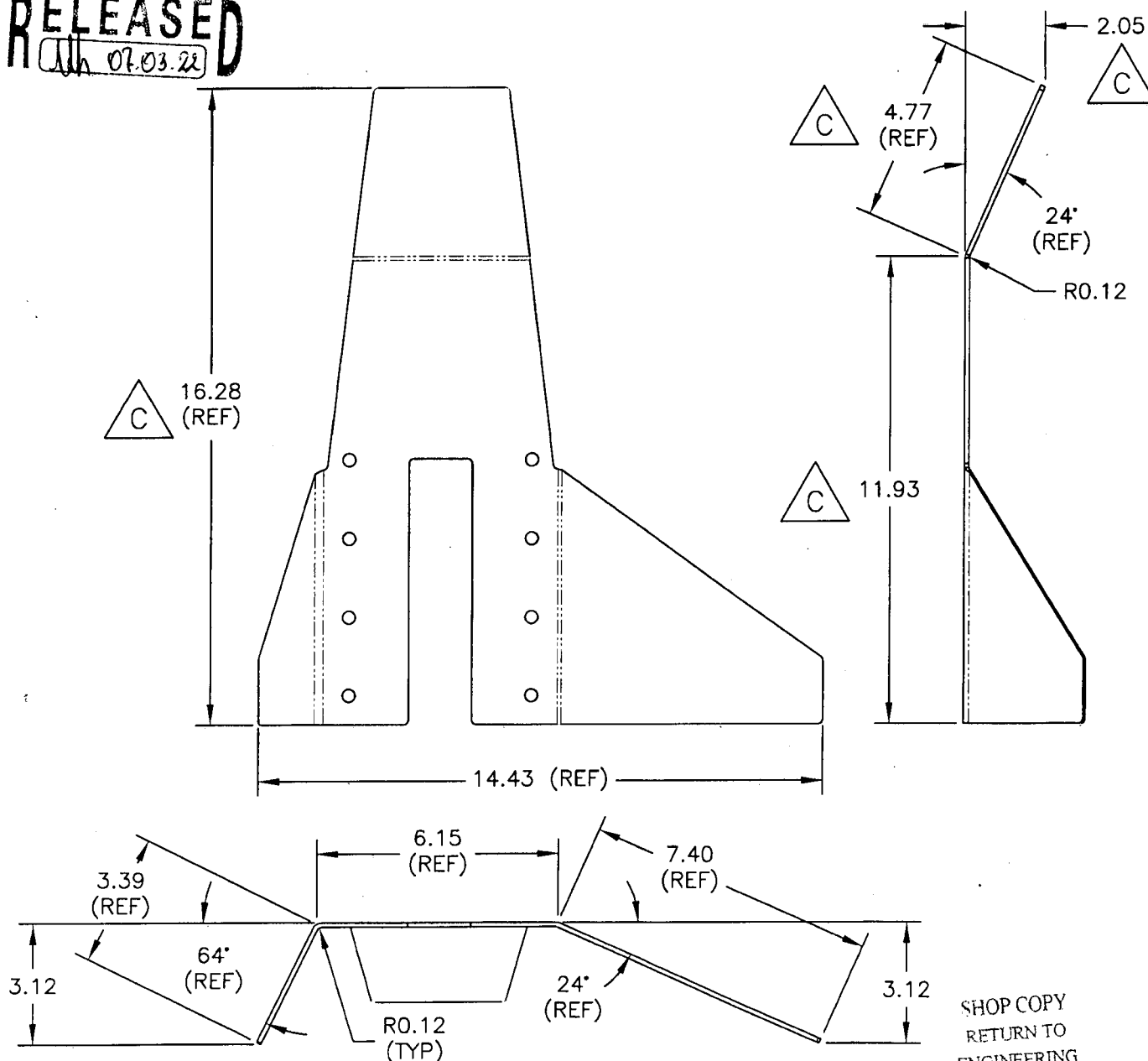
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07.03.22



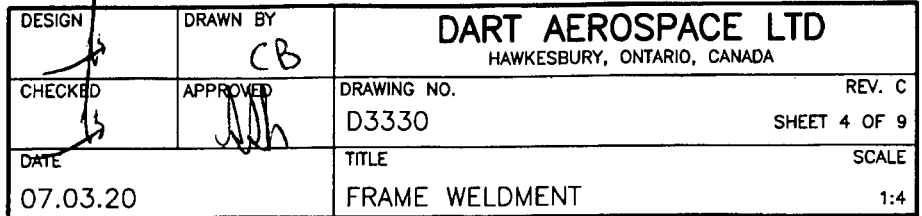
D3330-1 BEND DETAIL (SHOWN)

BEND D3330-2 (OPPOSITE)

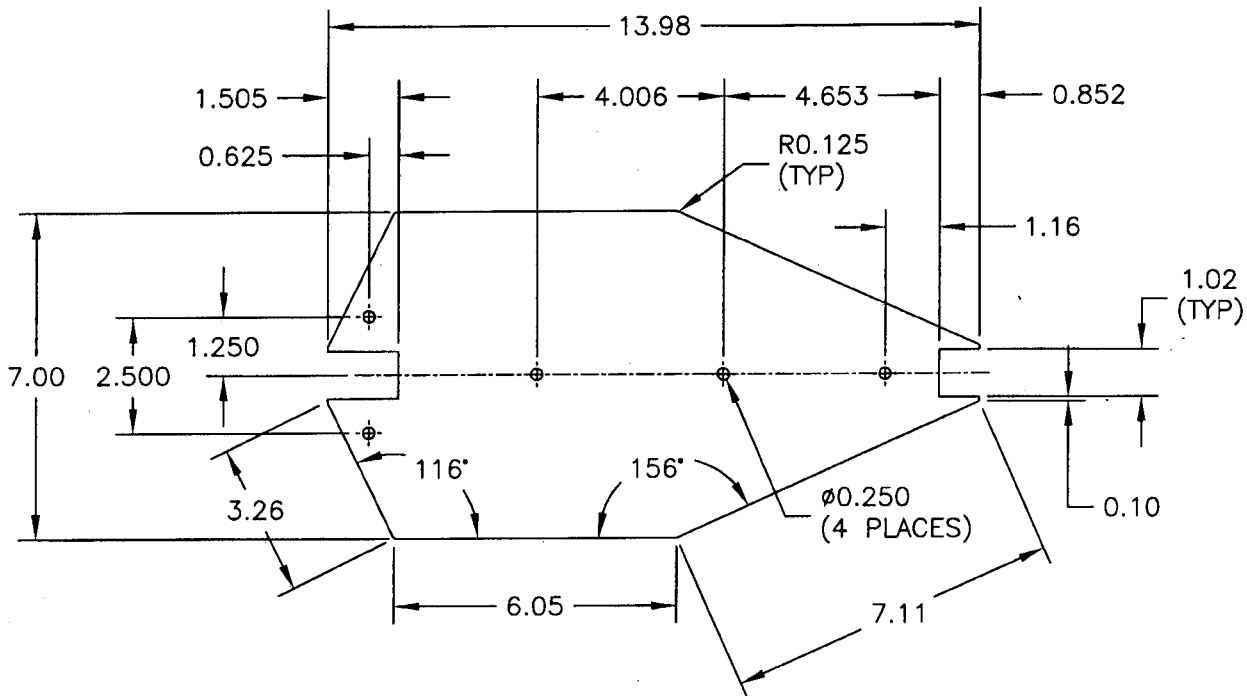
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RELEASED
JUL 07-03-24



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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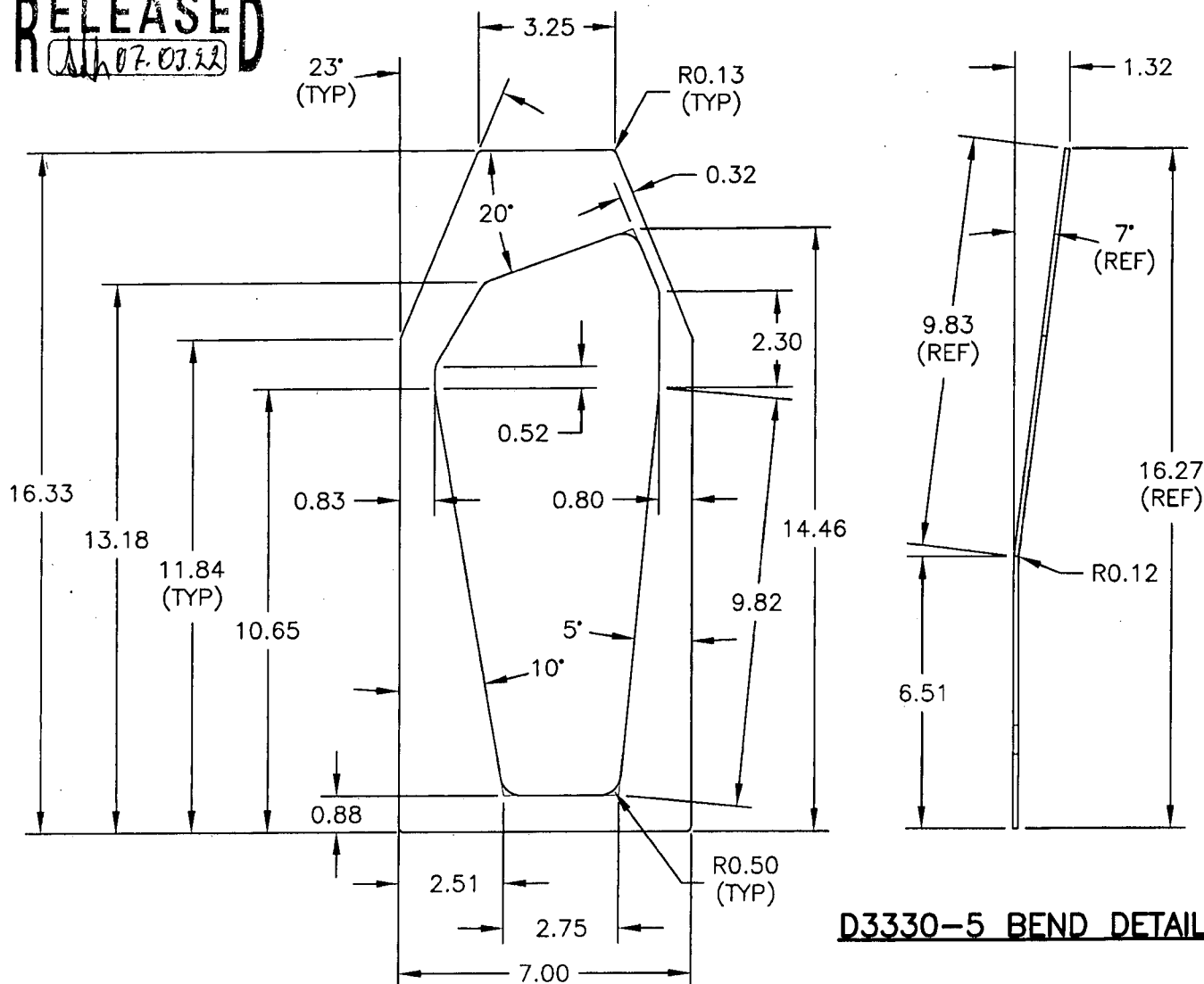
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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
07.03.22**D3330-5 BEND DETAIL****FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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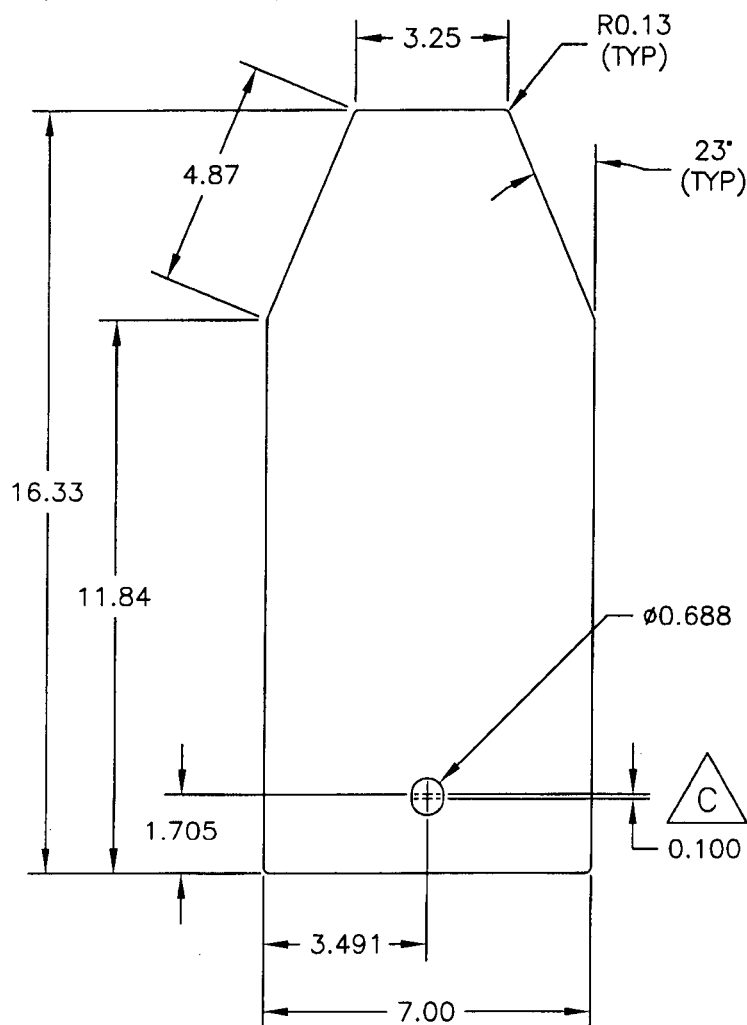
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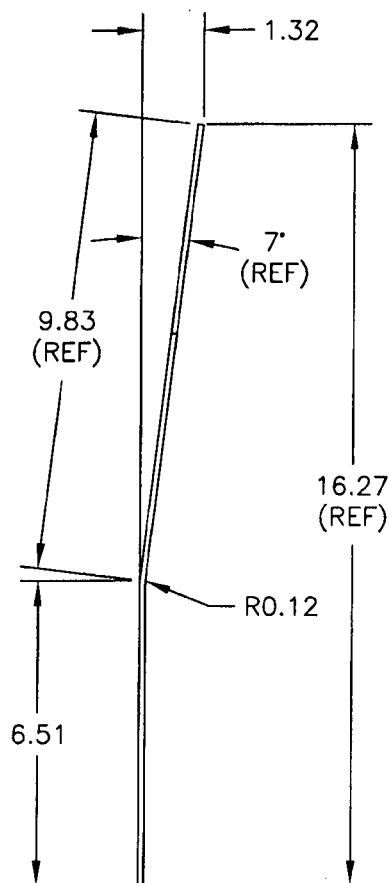


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RELEASED
07.03.22



FLAT PATTERN



D3330-7 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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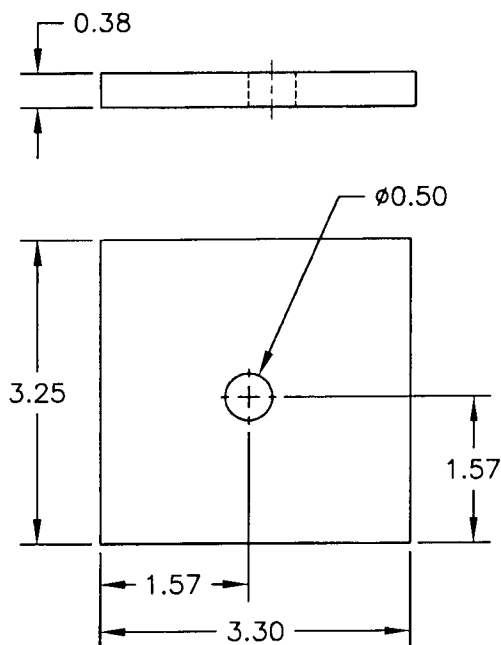
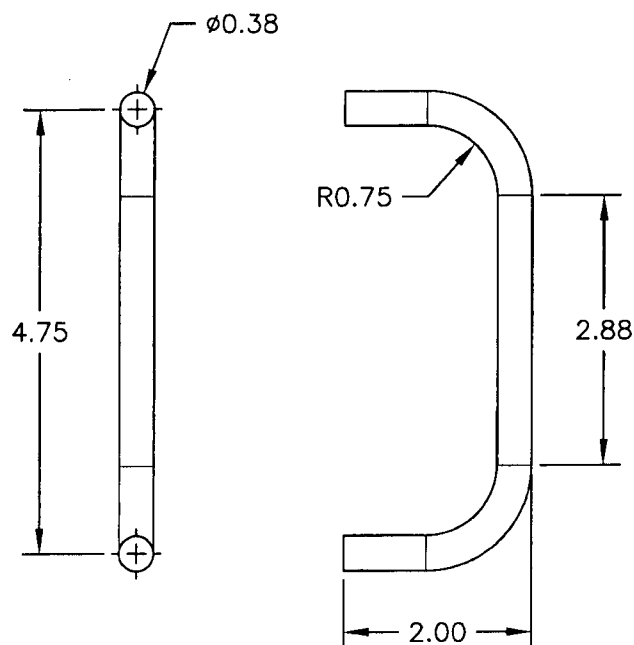
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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:2

RELEASED
07.03.22**△ D3330-9 TOP PLATE****△ D3330-15 HANDLE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

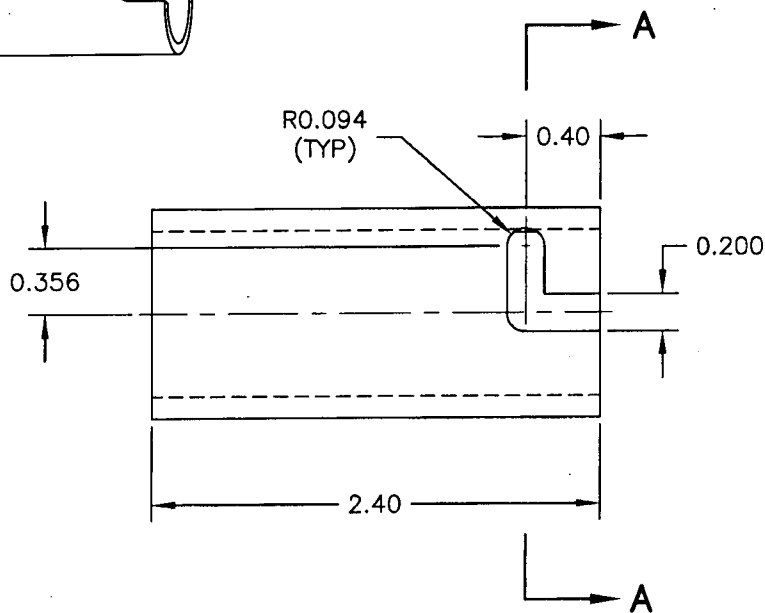
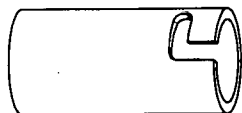
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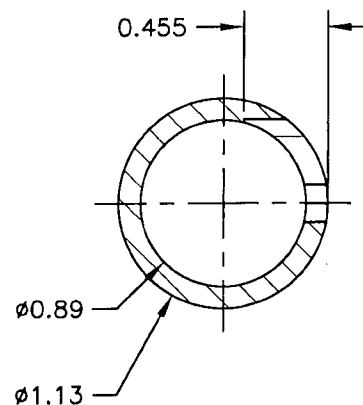
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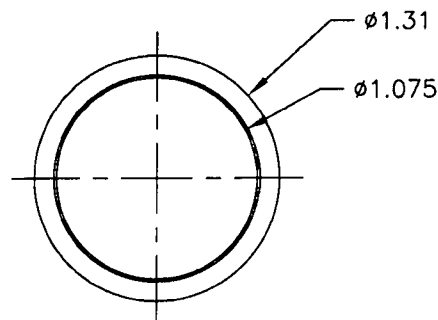
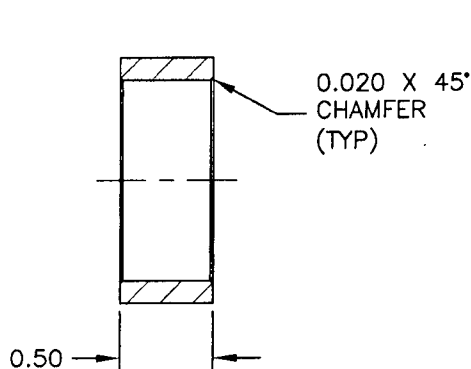


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07.03.22



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

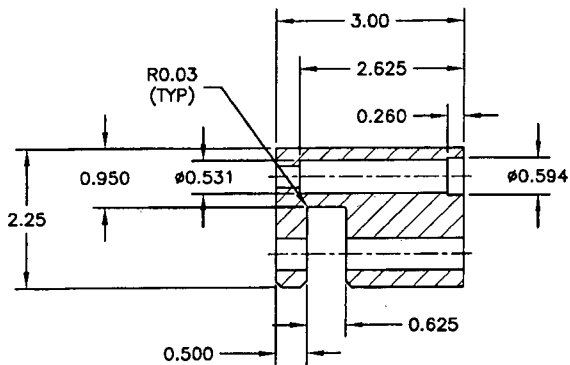
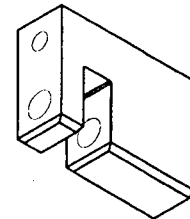
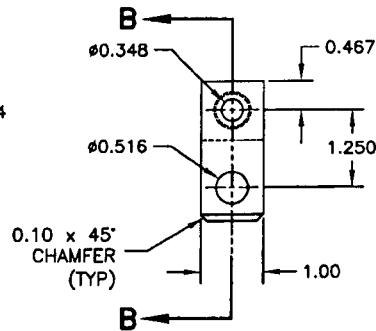
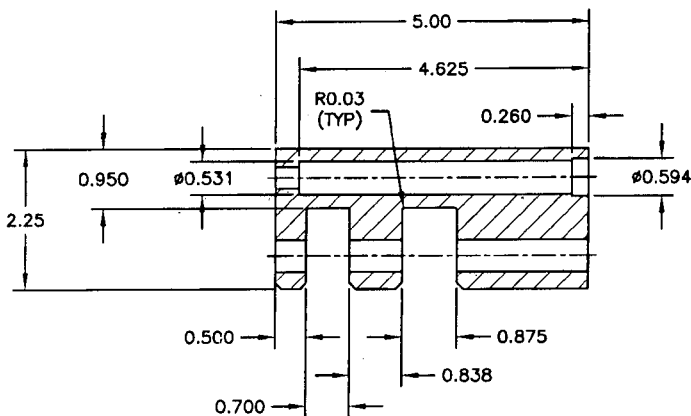
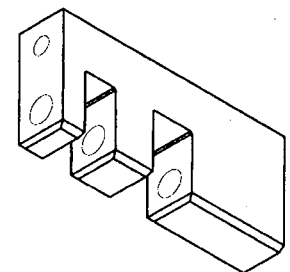
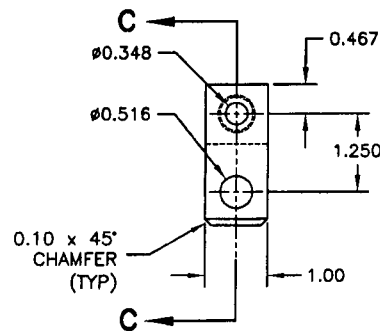
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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:3

RELEASED
07.03.22**SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
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